

ORIGINAL

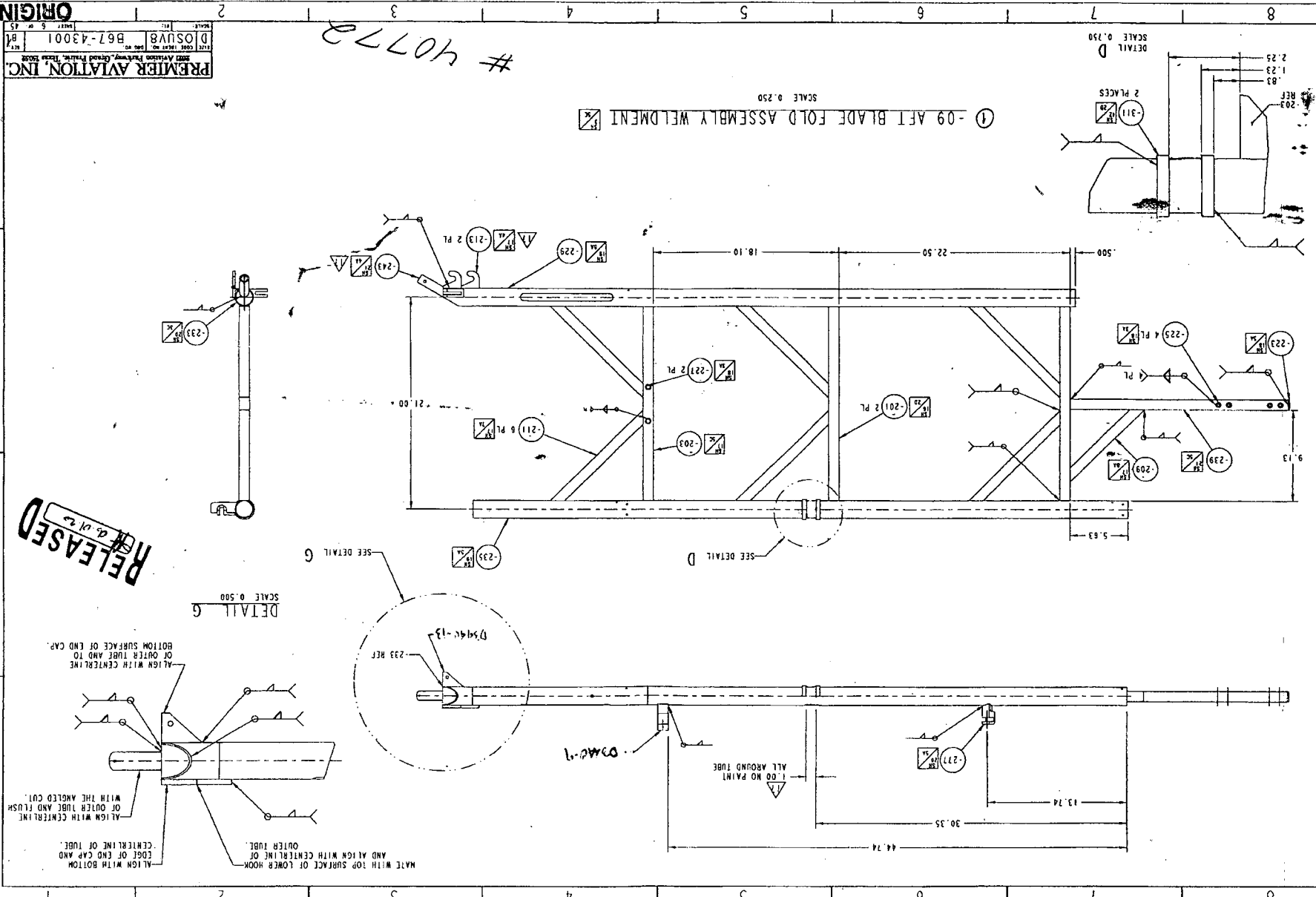
PREMIER AVIATION, INC.
2000 AVIATION PARKWAY, CHANDLER, ARIZONA 85226
DOWNS 8 B67-43001 R1

40772

① -09 AFT BLADE FOLD ASSEMBLY WELDMENT

SCALE 0.250

SCALE 0.250



RELEASED

DETAIL 6
SCALE 0.500

WELD WITH TOP SURFACE OF LOWER HOOK
AND ALIGN WITH CENTERLINE OF
OUTER TUBE.
ALIGN WITH CENTERLINE
OF END CAP AND
CENTERLINE OF TUBE.
ALIGN WITH CENTERLINE
OF OUTER TUBE AND FLUSH
WITH THE ANGLED CUT.
ALIGN WITH CENTERLINE
OF OUTER TUBE AND TO
BOTTOM SURFACE OF END CAP.

ALL AROUND TUBE
1.00 NO PAINT

Date: Tuesday, 29/07/2008 9:05:12 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT BLADE FOLD ASSY WELDMENT

Job Number: 40772

Part Number: PB674300109

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

QC21

FINAL INSPECTION/W/O RELEASE



08/08/06
HJ

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



u 08.08.06

Date: Tuesday, 29/07/2008 9:05:12 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT BLADE FOLD ASSY WELDMENT

Job Number: 40772

Part Number: PB674300109

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

D344013

Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Bracket

batch:- 324013B

1-7-12 08.08.07 3

14.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- assemble parts on jig DT8814 and weld as per dwg PB67-43001

ensure no burn thru after welding in tube -235 and -229

08.08.06 08.08.07 3

15.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 08-08-08 (3)

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/08/08 (x3)

17.0

POWDER COATING

POWDER COATING



M102316



(3X)

Comment: POWDER COATING

Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

8:15
320 °F
8:45

m. L 08/08/11

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-08-11 (x3)

19.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

39952

Date: Tuesday, 29/07/2008 9:05:12 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT BLADE FOLD ASSY WELDMENT

Job Number: 40772

Part Number: PB674300109

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PB6743001235

Outer Tube



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Outer Tube

batch:-

B 40771

Ph 08.07.31 3

7.0

PB6743001229

Outer Tube



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Outer Tube

batch:-

B 40779

Ph 08.07.31 3

8.0

PB6743001213

Flanged Hook



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Flanged Hook

batch:-

~~B 24000~~ B 40040

Ph 08.07.31 3

9.0

PB6743001311

Restraint



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Restraint

batch:-

M19695

Ph 08.07.31 3

10.0

PB6743001277

Contoured Hinge Arm



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Contoured Hinge Arm

batch:-

B 23828=1 B 40059=3

Ph 08.07.31 3

11.0

PB6743001243

Handle Arm Extension



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Handle Arm Extension

batch:-

B 40044

Ph 08.07.31 3

12.0

D34409

Tube Detent Clip Base



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Tube Detent Clip Base

batch:-

B 23736

Ph 08.07.31 3

Date: Tuesday, 29/07/2008 9:05:12 AM
 User: Linda Lacelle

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	AFT BLADE FOLD ASSY WELDMENT
Job Number :	40772		
Estimate Number :	13503		
P.O. Number :		Part Number :	PB674300109
This Issue :	29/07/2008	Drawing Number :	B6743001 P.6
Prsht Rev. :	NC	Project Number :	N/A
First Issue :	1/1	Drawing Revision :	B1
Previous Run :		Material :	
Written By :		Due Date :	05/08/2008
Checked & Approved By :	<u>CMF 08-07-29</u>	Qty:	3 Um: Each
Comment :	Est Rev:A 08-06-25 new issue DD verified by:ec		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
----------------	------------------------------	---------------------

1.0	PB6743001211	Square Tubing
-----	--------------	---------------



Comment: Qty.: 6.0000 Each(s)/Unit Total : 30.0000 Each(s)
 Square Tubing
 batch:- 340596

PL 08-07-31 3

2.0	PB6743001209	Square Tubing
-----	--------------	---------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)
 Square Tubing
 batch:- 340595

PL 08-07-31 3

3.0	PB6743001201	Square Tubing
-----	--------------	---------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)
 Square Tubing
 batch:- 340592

PL 08-07-31 3

4.0	PB6743001203	Square Tube
-----	--------------	-------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)
 Square Tube
 batch:- 340594

PL 08-07-31 3

5.0	PB6743001239	Square Tube
-----	--------------	-------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)
 Square Tube
 batch:- 340555

PL 08-07-31 3